

Work Order ID 149184 - 2 split

149184

Page 1

Thursday, July 21, 2016 10:54:18 AM

Item ID: D4635-2 Accept *N900040100* Setup Start *NS1*
 Revision ID: Stop *NS2*
 Item Name: Fwd Ceiling Panel, RH
 Start Date: 7/21/2016 Start Qty: 2.00 *2*
 Required Date: 7/28/2016 Req'd Qty: 2.00 *2*
 Reference: Cust Item ID: Customer:

Approvals: Process Plan: dm Date: 16/07/21 Tooling: _____ Date: _____ Run Start *NR1*
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D4635	F								DAS 07 9-89
100	HAND FINISHING THERMOFORMING	0.00							
100						2			
Thermoform	Memo	0.05							16/08/17
Thermoforming Machine	Cut Blanks								
105	Dry Material	0.00							DAS 07 9-89
105						2			
HandThermo	Memo	0.00							16/08/17
Hand Finishing Thermoforming	Dry Sheet as per QSI022 POLYCARBONATE								
	Temp: 245 deg. F								
	Time IN: 5:00 PM								
	6:00 AM								
	Time OUT:								
	Per.....								

AUG 16 2016

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :				MRB (QSI042) Approval	
Description Work Order Deviation				Disposition				Completed By 02 042 Lead hand / Supervisor Approval Verification 0-00 01 042 QC / QA Coordinator Approval	
Root Cause		FAULT CATEGORY							
Environment ☐	No Re-verification ☐	Pressure/Forced ☐	Temperature/Cure ☐	Power Loss/Surge ☐	Positioned Wrong ☐				
Design ☐	Operator ☐	Bending ☐	Set-up ☐	Folio/Program ☐	Outside Dimensions ☐				
Doc/Data ☐	Offset/Setup ☐	Centre Not Concentric ☐	BOM/Route ☐	Grain ☐	Over/Under tolerance ☐				
Equip/Tooling ☐	Supplier ☐	Cracks ☐	Broken/Damage/Defect ☐	Weld ☐	Part Incorrect ☐				
Handling/Pre ☐	Training ☐	Crimp/Kink/Ripple/Wave ☐	Inspection Incomplete/Unqualified ☐	Wrong Stock Pulled ☐	Part Lost/Missing ☐				
Material ☐	Use for Testing ☐	Cuffs ☐	Contamination ☐	Out of Sequence ☐	Part Moved ☐				
Internal Transport ☐	Poor Information ☐	Crushing ☐	Countersink ☐	Off-set ☐	Drawing ☐				
Tribal Knowledge ☐	Rushing ☐	Heat Treat ☐	Cut Too Short ☐	Mislabeled ☐	Finish ☐				
LOA ☐	Product Improvement ☐	Wave/Twist in Tube ☐	Instructions Incomplete/Unclear ☐	Fit/Function ☐	Misread ☐				
Substation ☐	Process Improvement ☐	Marks/Chatter ☐	Drill Holes ☐	Misaligned/off center ☐	Turning Sequence ☐				
Past Expiry Date ☐	Manufacturing Process ☐								
Misidentified ☐	Past Due ☐	OTHER :							

Thursday, July 21, 2016 10:54:18 AM

Page 2

[illegible]

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
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								Lead hand / Supervisor Approval Verification	
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Root Cause		FAULT CATEGORY							
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Misidentified ☐	Past Due ☐								

Work Order ID 149184

Thursday, July 21, 2016 10:54:18 AM

149184

Page 3

Item ID: D4635-2

Accept

N900040100

Setup Start

NS1

Revision ID:

Stop

NS2

Item Name: Fwd Ceiling Panel, RH

Start Date: 7/21/2016 Start Qty: 2.00

2

Cust Item ID:

Required Date: 7/28/2016 Req'd Qty: 2.00

2

Customer:

Reference:

Approvals:

Process Plan: _____

Date: _____

Tooling: _____

Date: _____

Run Start

NR1

QC: _____

Date: _____

SPC (Y/N): _____

Date: _____

Stop

NR2Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

140

140

QC

Quality Control

QC6- Inspect dimensions to drawing
Dimensional Inspection

0.00

Memo

Fill out Inspection Sheet Rev A

0.00

24

DAS
07
9-89
16/09/08

150

150

QC

Quality Control

QC5- Inspect part completeness to step on W/O

0.00

Memo

0.01

41

DAS
16
9-89
16/09/13

160

160

Packaging

Packaging

Packaging

Memo

0.00

0.00

x1

DL
16/09/28

W/O 149157

DQA: _____ Date: _____

**WORK ORDER NON-CONFORMANCE / UPDATE**

QA Closed: _____ Date: _____

Work Order update only ☒

Work Order: <u>149184</u> Part No. <u>D4635-2</u> NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS <table style="width:100%;"> <tr> <td>Skid-tube ☐</td> <td>Cross tube ☐</td> <td>Water Jet ☐</td> <td>Engineering ☐</td> </tr> <tr> <td>Machining ☐</td> <td>Small Fab ☐</td> <td>Prod. Eng. Coord. ☐</td> <td>Quality ☐</td> </tr> <tr> <td>Thermoforming ☐</td> <td>Finishing ☐</td> <td>Rec/Store/Packaging ☐</td> <td>Other ☐</td> </tr> <tr> <td>Large Fab ☐</td> <td>Composite ☐</td> <td>Supplier ☐</td> <td></td> </tr> </table>						Skid-tube ☐	Cross tube ☐	Water Jet ☐	Engineering ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	Large Fab ☐	Composite ☐	Supplier ☐																																															
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Work Order ID 149184

Thursday, July 21, 2016 10:54:18 AM

149184

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Item ID: D4635-2 Accept ***N900040100*** Setup Start ***NS1***
Revision ID: Stop ***NS2***
Item Name: Fwd Ceiling Panel, RH
Start Date: 7/21/2016 Start Qty: 2.00 ***2*** Cust Item ID:
Required Date: 7/28/2016 Req'd Qty: 2.00 ***2*** Customer:
Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
170	QC21- Final Inspection - Work Order Release	0.00							
170									
QC	Memo	0.03							
Quality Control									

DAS
21
9-89
SEP 30 2016
8m 16/09/29

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐			
Date : _____	Step #: _____	QTY Effective : _____		MRB (QSI042) Approval	
Description Work Order Deviation		Disposition		Completed By	
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Root Cause		FAULT CATEGORY			
Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐	No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐	Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐	Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐	Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Mislabeled ☐ Fit/Function ☐ Misaligned/off center ☐	Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐
OTHER : _____					

Picklist Print

Thursday, July 21, 2016 10:54:17 AM

Page 1

Work Order ID: 149184

149184

Parent Item: D4635-2

D4635-2

Parent Item Name: Fwd Ceiling Panel, RH

Start Date: 7/21/2016

Required Date: 7/28/2016

Start Qty: 2.00

Required Qty: 2.00

Comments: IPP Rev. A New Issue 12/05/07 DL VERIFIED BY:JLM IPP Rev. B
Dwg. Update 12/11/08 DL IPP Rev C Dwg. Update
13/07/09 DL IPP Rev D Dwg. Update, Material
Change 13/12/18 DL IPP Rev. E Dwg. Update 14/01/09
DL IPP Rev. F Dwg Update 15/01/27

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
MLEXS.093-F6006-07		Purchased	No			100	sf	380.9000	25.27	50.54			DAS 07 9-89

MI FXS 093-F6006-07

GE PLASTICS LEXAN SHEET (Grey)

Location

Loc Qty

Loc Code

MAT023

380.9

m129738

380.9

M135322

50.54 sf

12/08/17

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐			
Date : _____	Step #: _____	QTY Effective : _____		MRB (QSI042) Approval	
Description Work Order Deviation		Disposition		Completed By	
				Lead hand / Supervisor Approval Verification	
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				3-88 01 072	
Root Cause Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐ No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐		FAULT CATEGORY Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐ Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Misabeled ☐ Fit/Function ☐ Misaligned/off center ☐ Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐			
OTHER : _____					

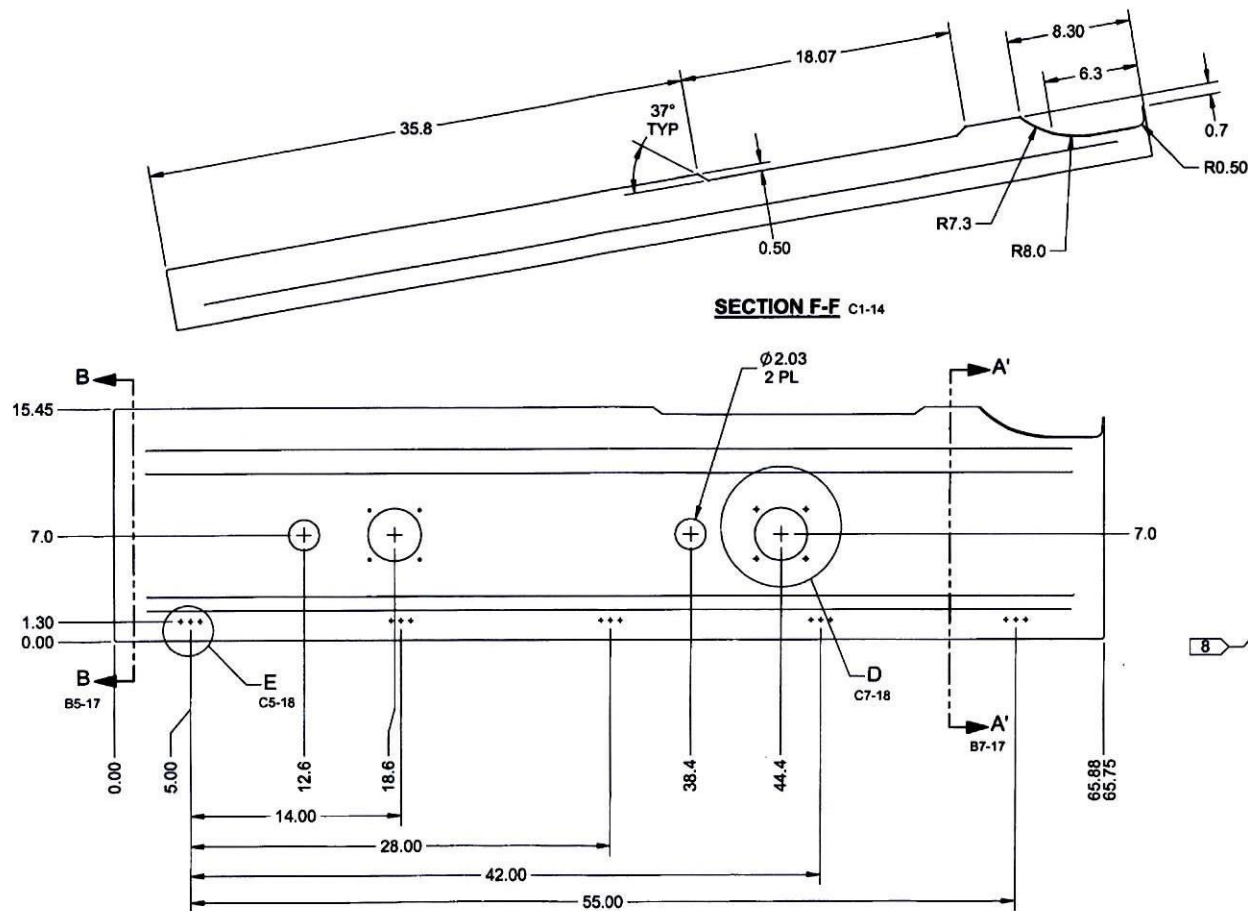
DART AEROSPACE LTD		Work Order:	149184
Description: RH Fwd Ceiling Panel		Part Number:	D4635-2
Inspection Dwg: D4635	Rev: EF 24	Page 1 of 1	

FIRST ARTICLE INSPECTION CHECKLIST

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
14.00	+/-0.030	14.0"	✓			
28.00	+/-0.030	28.0"	✓			
42.00	+/-0.030	42.0"	✓			
55.00	+/-0.030	55.0"	✓			
5.00	+/-0.030	5.0"	✓			
12.6	+/-0.100	12.6"	✓			
18.6	+/-0.100	18.6"	✓			
38.4	+/-0.100	38.4"	✓			
44.4	+/-0.100	44.4"	✓			
1.3	+/-0.100	1.3"	✓			
7.0	+/-0.100	7.0"	✓			
7.00	+/-0.030	7.0"	✓			
Ø2.03	+0.012/-0.001	Ø2.03"	✓			
Ø0.191	+0.005/-0.001	Ø0.191"	✓			
Ø3.50	+0.012/-0.001	Ø3.5"	✓			
3.300	+/-0.010	3.3"	✓			
1.650	+/-0.010	1.65"	✓			
Ø0.129	+0.005/-0.001	Ø0.129"	✓			
1.300	+/-0.010	1.3"	✓			
0.650	+/-0.010	0.65"	✓			
0.35 - 0.40	+/-0.030	0.365"	✓			
0.30	+/-0.030	0.33"	✓			
0.50	+/-0.030	0.51"	✓			

Measured by:	DAS 07 9-89	Audited by:	5	Preliminary Approval:	
Date:	16/09/08	Date:	16/10/03	Date:	

Rev	Date	Change	Revised by	Approved
A	14.07.29	New Issue	KJ	



NOTES:

1) MATERIAL: F6006 SUEDE/POLISHED GY5B133 LIGHT GREY LEXAN SHEET 0.093 THICK
(REF DART SPEC MLEXS.093-F6006-07)

2) FINISH: N/A

3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED

4) UNITS: INCHES UNLESS OTHERWISE NOTED

5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX

6) IDENTIFICATION: N/A

7) WEIGHT: 4.37 lbs

8) TEXTURE ON THIS SIDE

9) TRIM D4635-2 PER TOOL DT9840

10) THERMOFORM D4635-2 PER QSI 022 USING DT9847 TOOL

MIN. THICKNESS AFTER FORMING:

SHADED AREA = 0.040

RIDGES/EDGES = 0.060

ELSEWHERE = 0.070

D4635-2 RH, FWD CEILING PANEL

RELEASED

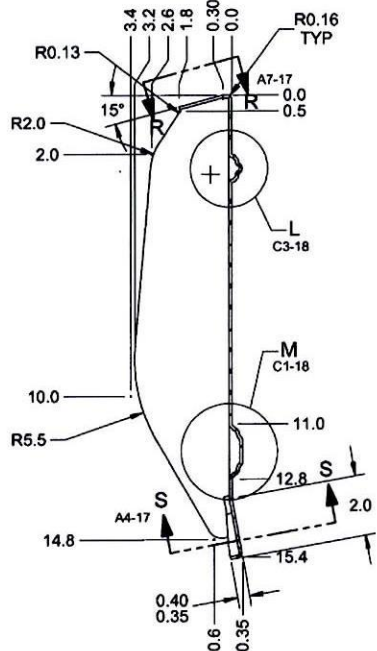
2015 JAN 26

APPROVED

DESIGN	RF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	RF		
CHECKED	AK	DRAWING NO.	REV. F
MFG. APPR.	DL	D4635	SHEET 14 OF 18
APPROVED	HS	TITLE	SCALE
DE APPR.	DS	OUTBOARD CEILING PANELS	NTS
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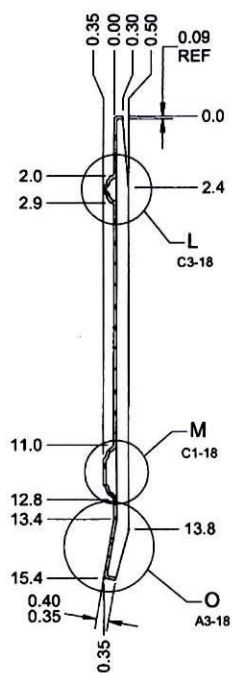
w/o 149184

2m 16/07/21



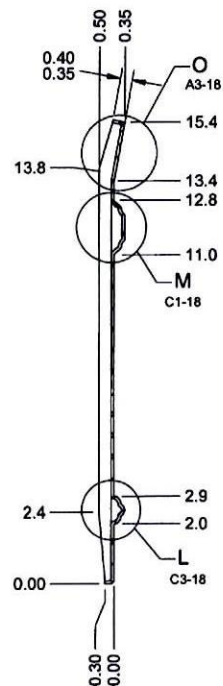
SECTION A-A
SECTION A-A' OPPOSITE
SCALE 2X

B3-13
B3-14



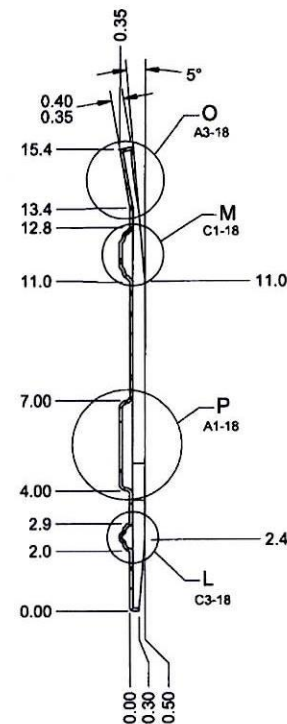
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B7-13
B7-14



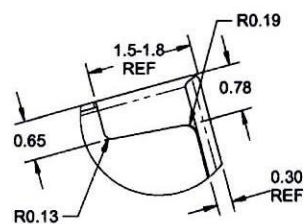
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B4-15
B4-16



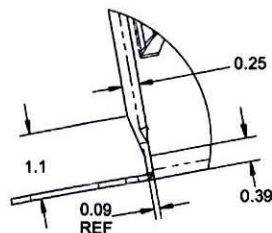
SECTION K-K
SCALE 2X

C6-16



AUXILIARY VIEW R-R
SECTION R-R' OPPOSITE
SCALE 2X

D7-17



AUXILIARY VIEW S-S
SECTION S-S' OPPOSITE
SCALE 2X

B7-17

RELEASED

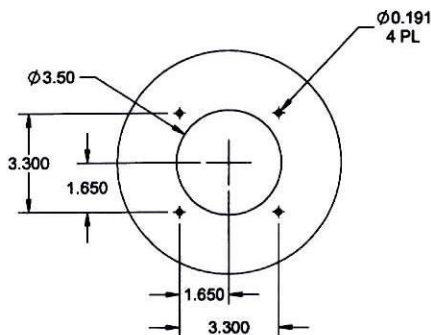
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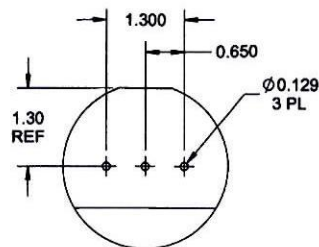
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DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWING NO. D4635	REV. F
TITLE OUTBOARD CEILING PANELS	SCALE NTS
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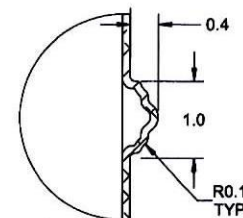
SHEET 17 OF 18



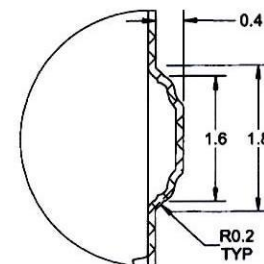
DETAIL D
SCALE 2X
B4-13
B3-14
B5-15
B5-16



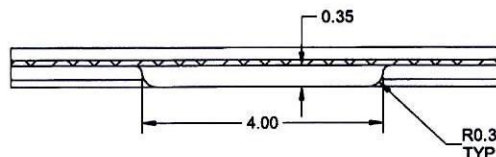
DETAIL E
SCALE 4X
C7-13
B6-14
C8-15
B5-16



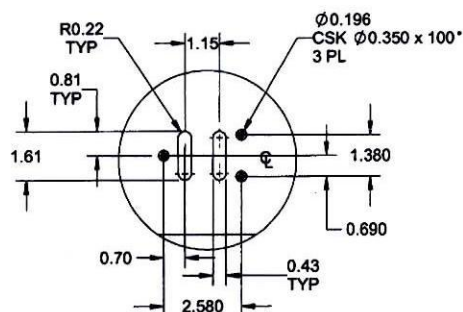
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SCALE 1.5X
B2-17
B4-17
C5-17
C7-17



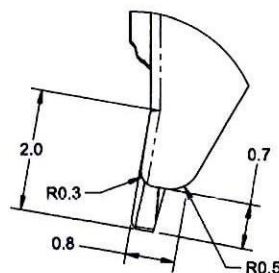
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SCALE 1.5X
C2-17
C3-17
C5-17
C7-17



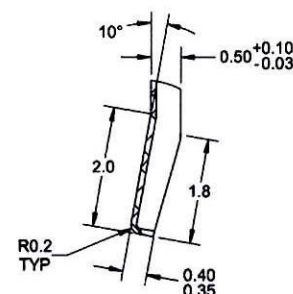
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B5-16



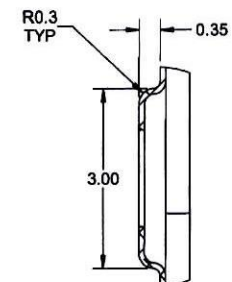
DETAIL Q
SCALE 2X
C5-16



DETAIL N
SCALE 2X
B2-13



DETAIL O
SCALE 2X
D2-17
D3-17
B5-17



DETAIL P
SCALE 4X
C2-17

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DRAWN	RF	HAWKESBURY, ONTARIO, CANADA	
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